

Date: Monday, 8/13/2007 10:03:12 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR DOUBLER
Job Number : 33876	
Estimate Number : 12942	
P.O. Number : N/A	Part Number : D3594044
This Issue : 8/13/2007 S.O. No. : N/A	Drawing Number : D3594 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 33552	Material : N/A
Written By : <u>SA 07-08-13</u>	Due Date : 8/20/2007 Qty: 30 Um: Each
Checked & Approved By : _____	
Comment : Est Rev : A New Issue 07-01-22 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.5355 sf(s)/Unit Total : 16.0650 sf(s)
 6061-T6 .080 Sheet
 Batch: 14104921

SA 07/08/13

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3594
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

mf 07/08/20 30
SA 07/02/13 30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07/08/13 30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 07/08/20

30
SA 07/08/20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 C'SINK AS PER DWG D3594

mf 07-08-21

30
PTO
See last page.



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Part Number: D3594044

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/23 (30-044)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-08-27 (30)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/30 (30)

9.0 MS210695 Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Anchor nuts

BATCH: M104214 (30)

M105513 (27x)

10.0 MS20426AD44 Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

Rivet

BATCH: M1021

07/10/30

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

07/10/30 (30)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/06 (430)

POSITIVE
RECALL

13.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST188

W

AR

07/11/08
POSITIVE RECALL

EFFECTIVE 070822 AUTH

RELEASED

DATE

07/13

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Drawing Name: DOOR DOUBLER

Job Number: 33876

Part Number: D3594044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

17/08/09

Job Completion



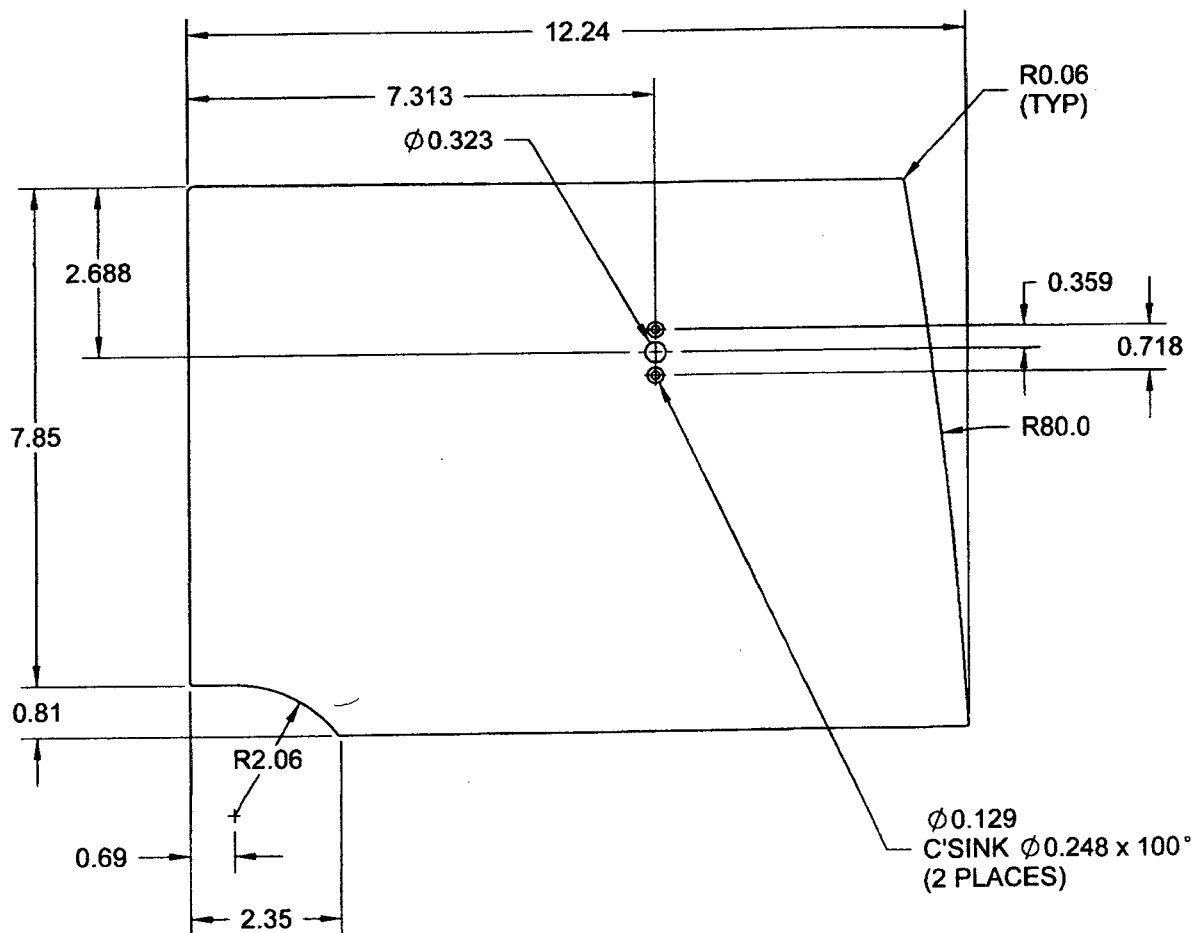
17/08/09



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3594	REV. A SHEET 3 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:3

RELEASED
07.07.11 *B*

Per 66141001



D3594-3 FLOOR DOUBLER
(D3594-4 OPPOSITE)

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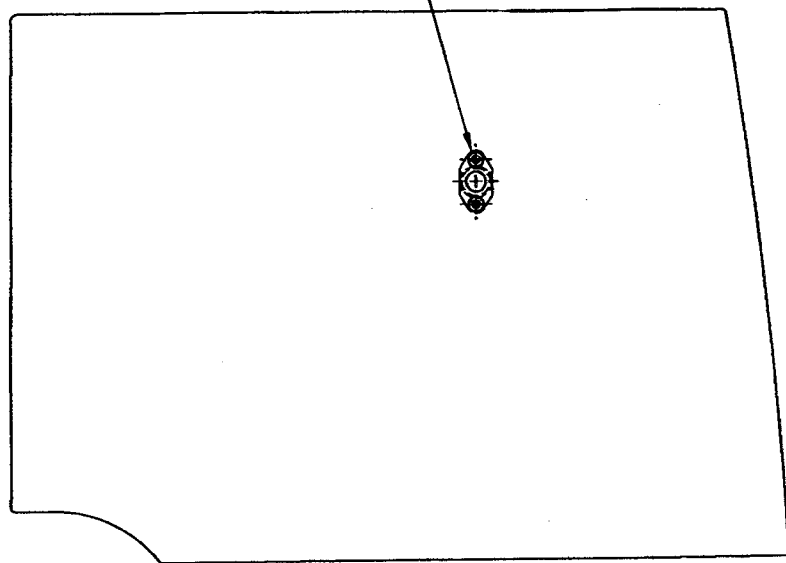


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3594	REV. A SHEET 2 OF 3
DATE 07.04.13		TITLE FLOOR DOUBLER ASSEMBLY SCALE 1:3	

RELEASED
07.07.11

Per 604101

MS20426AD4-4 RIVET
(2 PLACES)



D3594-3 FLOOR DOUBLER (D3594-043)
D3594-4 FLOOR DOUBLER (D3594-044)

MS21069-5
ANCHOR NUT



D3594-043 FLOOR DOUBLER ASSEMBLY
(D3594-044 OPPOSITE)

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

NOTES:

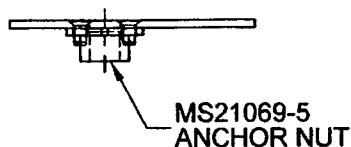
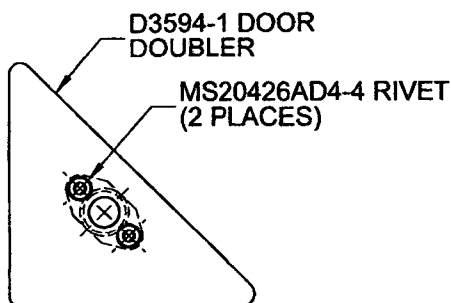
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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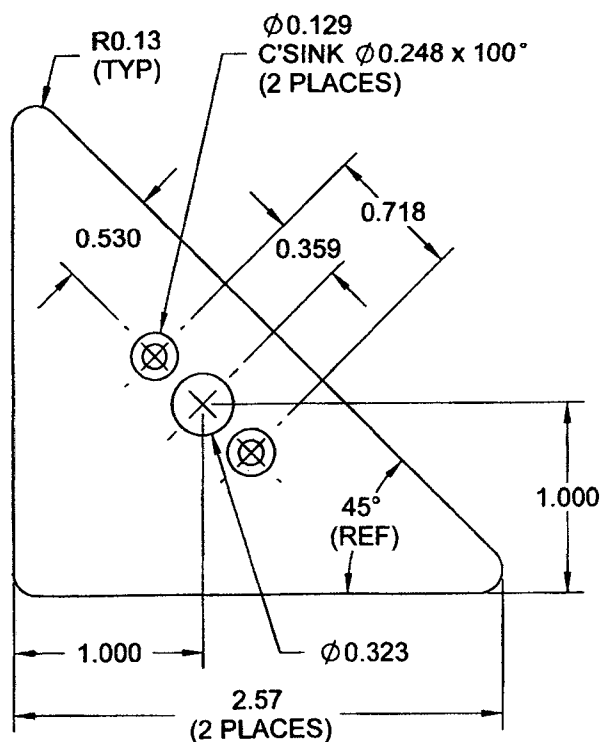
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DART**RELEASED**
07.07.11
Per [signature]

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3594	REV. A SHEET 1 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3594-041 DOOR DOUBLER ASSEMBLY**
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX


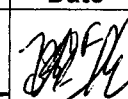
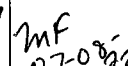
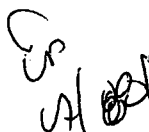
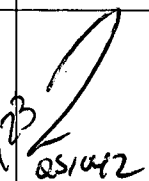

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-08-22	6-0	Assembly					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-22	5-0	1 part has 1 hole that was countersunk too deep. R.C: Human error.	 QS1042	Material is 6061-T6. Fill hole with weld per QS1004, and grind flush. Reel A/R  Using MS20426 MS20426-5 nut plate. Transfer drill hole, and re-countersink.	 MF 07-08-22	 Ep 07-08-22	 QS1042	 Ep 07-08-22

NOTE: Date & initial all entries